

Work Order ID 139802***139802***

Page 1

Item ID: D206-667-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Crosstube - High 206 A/B

Start Date: 12/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/9/2015 Req'd Qty: 1.00

1

Customer:

Reference: NCR15-5496

Approvals: Process Plan: MFDate: 15-12-08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-141	Rev C (DEO)								
DSI9565	A								
DSI9628	A								

MCS DEC 09 2015

310

0.00

310

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D206-667-101 X 1 B135130

REMOVE NAS1149D0563J X 18 AND SCRAP PER NCR15-5496

ADD NEW NAS1149D0563J X 18 B 133363

ID AND STOCK UNDER NEW BATCH NUMBER

DEC 09 2015

DAS
28
9-89

320

QC5- Inspect part completeness to step on W/O

0.00

320

QC

Memo

0.00

Quality Control

DAS
27
9-89
DEC 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 139802

Tuesday, December 08, 2015 3:57:06 PM

139802

Page 2

Item ID: D206-667-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fwd Crosstube - High 206 A/B

Stop

NS2

Start Date: 12/8/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/9/2015 Req'd Qty: 1.00

1

Customer:

Reference: NCR15-5496

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

330

Identify as per dwg & Stock Location: 16103

0.00

330

Packaging

Memo

0.00

Packaging

~~DAS~~

28

BAS

~~9-89~~

27

DEC 09 2015

9-89

340

QC21- Final Inspection - Work Order Release

0.00

340

QC

Memo

0.00

Quality Control

MCS

DEC 09 2015

MCS DEC 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, December 08, 2015 3:57:05 PM

Page 1

Work Order ID: 139802

139802

Parent Item: D206-667-101

D206-667-101

Parent Item Name: Fwd Crosstube - High 206 A/B

Start Date: 12/8/2015

Required Date: 12/9/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:F05.09.01Add holes for compatibility with Bell SkidtubesKJ/JLM
 IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec
 IPP Rev:H 08-07-28 update as per (par 08-013) DD verified by:EC
 IPP Rev J 09.01.06 Per ECN 08-562 EC verified by:DD IPP REV:K
 11.08.05 PER ECN 11-615 DD VERF:EC IPP REV:L 12.08.20
 DSI9628 revA (ECN12-631) DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-667-101		Manufactured	No				Each	0.0000		1			
D206-667-101									**				
Fwd Crosstube - High 206 A/B										1 X 135130			mf 15-12-08
NAS1149D0563J		Purchased	No				Each	1,301.000		18			
NAS1149D0563.J									**				
Washer													

Location	Loc Qty	Loc Code
GA	53	
m125807	53	
ST260a	528	
m130799	63	
m132035	55	
m132256	10	
m133769	400	
ST263	545	
m133134	129	
m133363	416	
ST269	156	
m128257	156	
ST271	19	
m131026	19	

DEC 09 2015

6
9-89

18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																														
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List Lots

Tuesday, December 08, 2015 2:55:44 PM

Page 1 of 1

Criteria : Item ID: d206-667-101 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D206-667-101 Fwd Crosstube - High 206 A/B	Main Warehouse FG103	135128	12/7/2015	1.0000	QC21	CHG005	
	Main Warehouse FG103	135129	12/7/2015	1.0000	QC21	CHG005	
	Main Warehouse FG103	135130	12/7/2015	1.0000	QC21	CHG005	
Total:				3.0000			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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